



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5415-3
Job Sheet 194263



Part No: D5415-3

Job Qty: 4 pcs

Part Name: STD Height Saddle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/29/19

Job Tracking No:

Due Date: ~~5/1/19~~ 5/09/2019

Created By: Patrick Lussier

Type: Stock

Description:

Note: D5415 REV.D IPP REV:A 16.09.16 NEW ISSUE DD VERF:JFS IPP REV:B 18.09.18 AS PER DWG REV.C DD VERF:JFS IPP REV:C 19.02.15 NOW OUTSOURCE MACHINE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Workcenter / Supplier Lead Time	Sign-off
100	Purchasing	1 pcs	5/1/19		0.00	0.00	Purchasing - 1		MAY 09 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	1 pcs	5/1/19		0.00	0.00	Packaging 2 - 1 - B4B		MAY 09 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		

ART
OSPACE

No: S179681



15-3
94263
Batch: S179681

Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/09/19



Container No: S179681



Part: D5415-3

Job No: 194263

Serial No/Batch: S179681

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA
TEL.: 1 613 632-5200
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www.dartaerospace.com

Date: 05/09/19

MAY 23 2019 Plex 4/29/19 1:49 PM dart.Lussier.Patrick

Part Op **100** - Issue P/O: 042148 Manufacture D5415-3 as per Dwg D5415 Possible supplier : ETM industries Material Descriptions: release note is required.

110 - (Receive & Inspect for Damage & Mat'l Certs)

111 - (QC6- All purchased or subcontracted products)

150 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

https://www.plexonline.com/cc940122-eb4f-4648-9354-9e73e7d2a421/Plexus_Control/Report_View/2.asp?URL=https://www.plexonline.com/cc940... 2/3

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D5415-3P	STD Height Saddle	1 pcs (1 ea)	100-Purchasing	S179679
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D5415-3P	1	0	0
Part Specifications				
Specifications could not be found.				

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PURCHASE ORDER

PO042148



Supplier: ETM001-VC
E.T.M. Industries Inc.
310 Hall Avenue, Box 610
Renfrew
ON
K7V 4E7 Canada
Phone: 613-432-6136
Fax: 613-432-8212

PO No: PO042148
PO Date: 1/3/19
Due Date: 7/3/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	193389	D5415-1P			Mid Height Saddle : Various STC's	Received	-	4/15/19	2 Ea	2 Ea	0 Ea	\$975.00/Ea	\$0.00
Line Item Note FIRST ARTICLE INSPECTION BY DART QTY OF 1 BEFORE TOTAL PRODUCTION (MATERIAL 7050-T7451 OR T7651) 2 first units No Alodine , No Paint													
2	193390	D5415-3P			STD Height Saddle : Various STC's	Received	-	4/15/19	2 pcs	2 pcs	0 pcs	\$975.00/pcs	\$0.00
Line Item Note FIRST ARTICLE INSPECTION BY DART QTY OF 1 BEFORE TOTAL PRODUCTION (MATERIAL 7050-T7451 OR T7651) 2 first units No Alodine , No Paint													
3	194260	D5415-1P			Mid Height Saddle : Various STC's	Firmed	-	5/9/19	2 Ea	0 Ea	2 Ea	\$975.00/Ea	\$1,950.00
4	194261	D5415-1P			Mid Height Saddle : Various STC's	Firmed	-	6/5/19	6 Ea	0 Ea	6 Ea	\$975.00/Ea	\$5,850.00
5	194262	D5415-1P			Mid Height Saddle : Various STC's	Firmed	-	7/3/19	14 Ea	0 Ea	14 Ea	\$975.00/Ea	\$13,650.00
6	194263	D5415-3P			STD Height Saddle : Various STC's	Firmed	-	5/9/19	2 pcs	0 pcs	2 pcs	\$975.00/pcs	\$1,950.00

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PURCHASE ORDER

PO042148



Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	194264	D5415-3P			STD Height Saddle : Various STC's	Firmed	-	6/5/19	6 pcs	0 pcs	6 pcs	\$975.00/pcs	\$5,850.00
8	194265	D5415-3P			STD Height Saddle : Various STC's	Firmed	-	6/19/19	10 pcs	0 pcs	10 pcs	\$975.00/pcs	\$9,750.00
9	194266	D5415-3P			STD Height Saddle : Various STC's	Firmed	-	7/3/19	10 pcs	0 pcs	10 pcs	\$975.00/pcs	\$9,750.00
Grand Total:													\$48,750.00

Order Notes

Procurement Quality Clauses
 A005 RIGHT OF ENTRY
 A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
 A012 CHEMICAL AND PHYSICAL TEST REPORTS
 A016 PERSONNEL QUALIFICATION
 A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
 A026 CERTIFICATION OF MATERIAL CONFORMANCE
 A041 QUALITY MANAGEMENT SYSTEM
 A042 DART NOTIFICATION BY SUPPLIER
 A043 RETENTION OF QUALITY DOCUMENT

 A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
 A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/9/19 12:50 PM dart.Lussier.Patrick

E.T.M. INDUSTRIES INC.
310 HALL AVENUE
BOX 610
RENFREW, ON K7V 4E7
Canada

41

Ph: 613-432-6136

Fax: 613-432-8212

Pack List

Number: 142484

Date: 06-May-19

To

DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-5246

Ph: 613-632-5200

Fax: 613-632-5246

Terms		Ship Via	
Net 30 days			
Quantity	Description		
1 each	Part: D5415-3P STD HEIGHT SADDLE:VARIOUS STC SO: 25055 Ordered: 9 **LOT #105812		
	Rev: C PO: PO042148 Line: 007 Backordered: 6		
CERTIFICATE OF COMPLIANCE: "I hereby certify that the material described above is in conformance with applicable physical and dimensional specifications; that it was manufactured in accordance with applicable process specifications; and has been inspected to verify conformance to those specifications." APPROVED SIGNATORY (QUALITY ASSURANCE)			

DAS
40
9-89

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MAY 09 2019

DART AEROSPACE LTD.

E.T.M. INDUSTRIES INC.
310 HALL AVENUE
BOX 610
RENFREW, ON K7V 4E7
Canada

2

Ph: 613-432-6136

Fax: 613-432-8212

Pack List

Number: 142483

Date: 06-May-19

To

DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

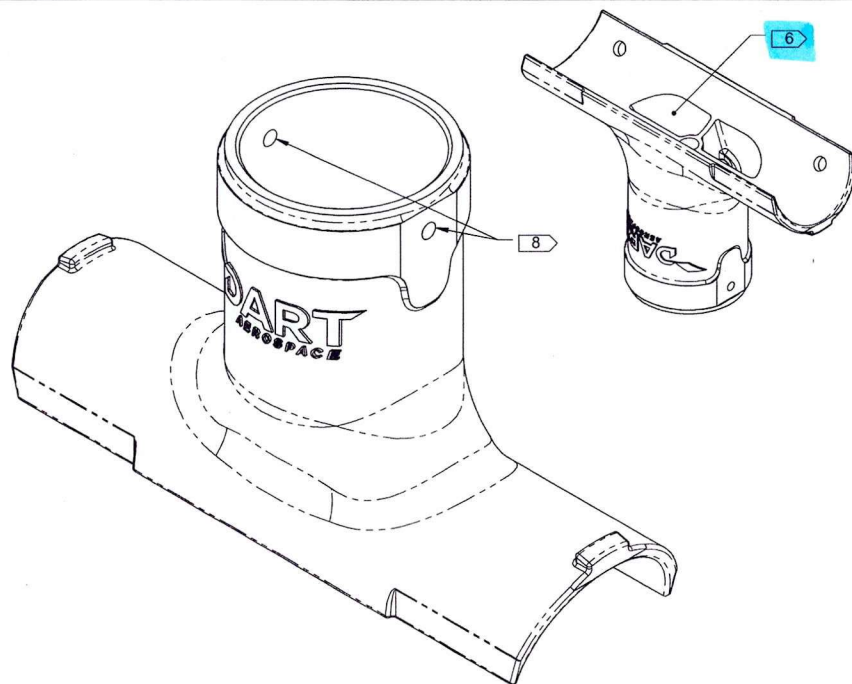
Ph: 613-632-5200

Fax: 613-632-5246

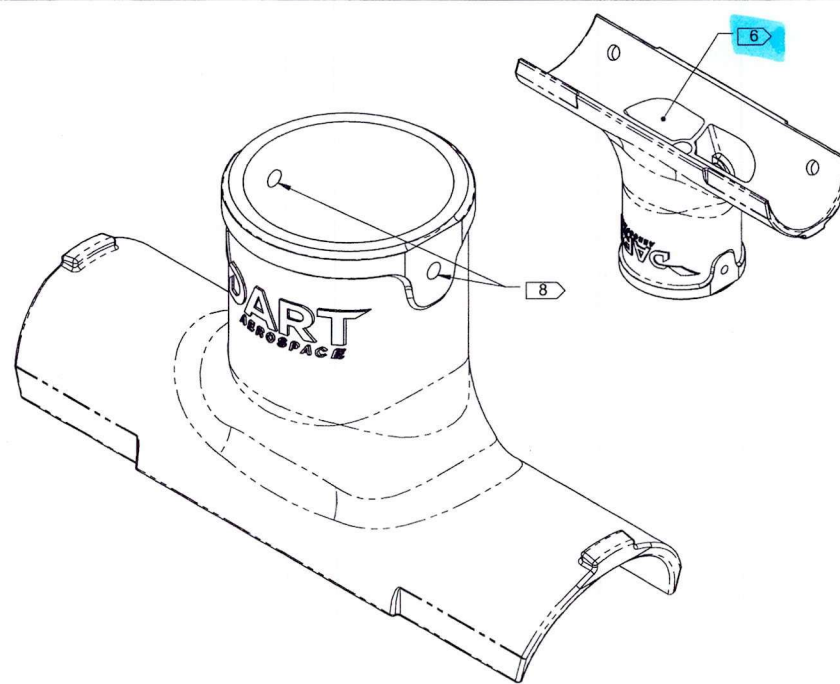
Ph: 613-632-5200

Fax: 613-632-5246

Terms		Ship Via	
Net 30 days			
Quantity	Description		
1 each	Part: D5415-3P STD HEIGHT SADDLE:VARIOUS STC ****FAI REQ'D OF 1 PC BEFORE TOTAL PRODUCTION (MATERIAL 7050-T7451 OR T765) SO: 25055 **LOT #105812 PO: PO042148 Line: 006 Rev: C		
CERTIFICATE OF COMPLIANCE: "I hereby certify that the material described above is in conformance with applicable physical and dimensional specifications; that it was manufactured in accordance with applicable process specifications; and has been inspected to verify conformance to those specifications." APPROVED SIGNATORY (QUALITY ASSURANCE) DAS 40 9-89 RECEIVED MAY 09 2019 DART AEROSPACE LTD.			



D5415-1 MID HEIGHT SADDLE



D5415-3 STANDARD HEIGHT SADDLE

NOTES:

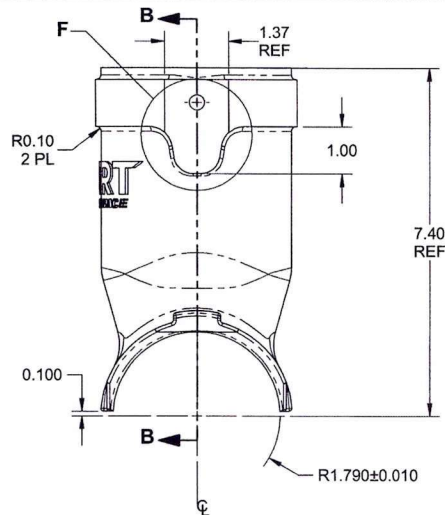
- 1) MATERIAL: MAKE FROM D5415-1C/-3C
- 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: DART P/N "D5415-1" OR "D5415-3" AND S/N PER QSI 044 6.4 (VIBRATING STYLUS) PRIOR TO FINISH
DART P/N "D5415-1" OR "D5415-3" AND S/N PER QSI 044 6.1 (PAINT MARKER) AFTER FINISH
LOCATE APPROX AS SHOWN
- 7) WEIGHT: D5415-1 is 3.72 LBS, D5415-3 is 3.42 LBS
- 8) MASK HOLES PRIOR TO PRIME AND PAINT

RELEASED

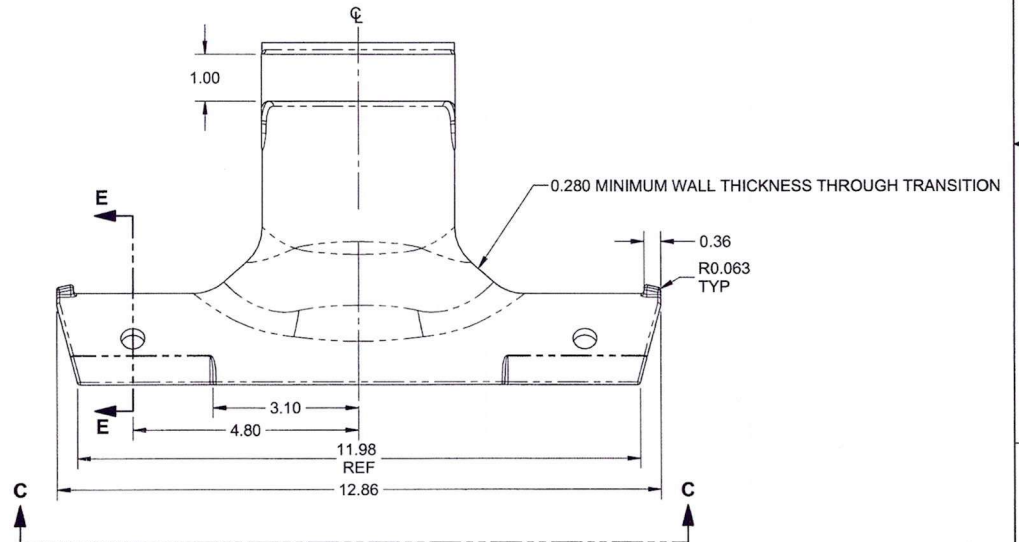
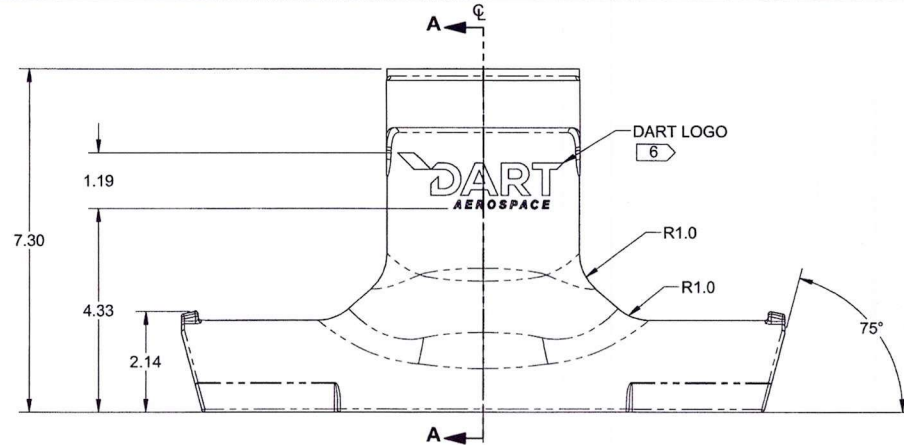
2010 FEB 15
ECN 17-593

D	ADDED 7050 ALUMINUM PLATE AS ALTERNATE MATERIAL FOR -1C/-3C	ZF	19.01.28
C	REDESIGNED SADDLE ALIGNMENT METHOD, INCORPORATED SADDLE RADIUS WASHER (D5562-1) INTO CASTING. SHEET 1: ADDED NOTE 8. SHEET 4: 3.565 WAS 3.550, 2.715 WAS 2.700.	MW	18.08.29
B	ADDED -3 STANDARD HEIGHT SADDLE, REVISED NOTES, REMOVED CAST P/N FROM -1 SADDLE. Ø0.323 HOLE WAS Ø0.325, SECTION B-B AND D-D ±0.005 WAS ±0.010	ML	17.09.05
A	NEW ISSUE	ML	16.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. D
MFG. APPR.	RQ	D5415	SHEET 1 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	SADDLE	NTS
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D5415-1C MID HEIGHT SADDLE



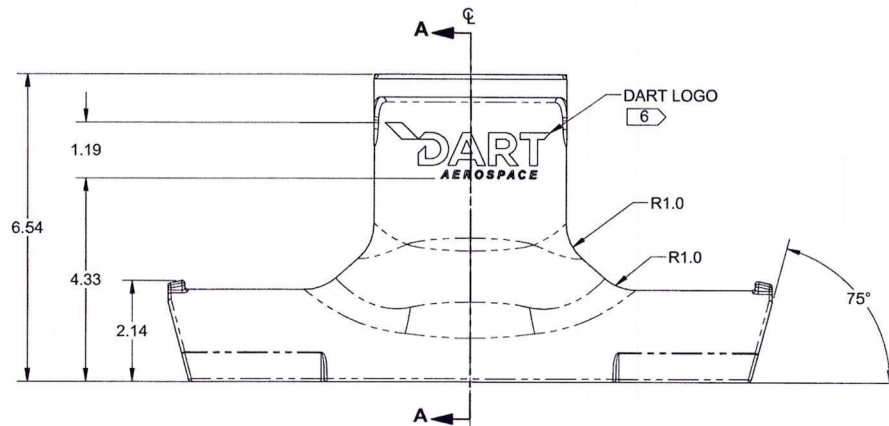
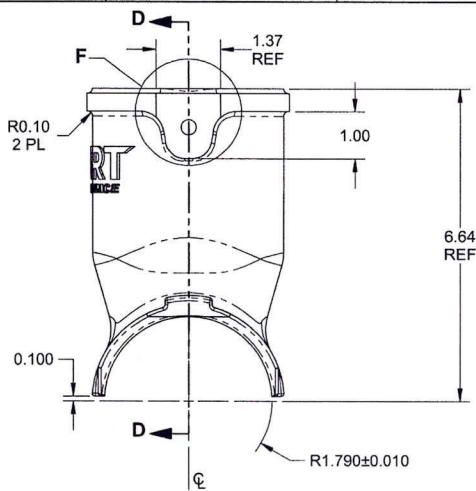
NOTES:

- 1) MATERIAL: CAST FROM F357.0 PER AMS 4289 AND HEAT TREAT TO T6 CONDITION
PROPERTIES TO BE VERIFIED BY SUB-SIZED SEPARATELY CAST TEST BARS
OR
MACHINE FROM 7050-T7451 OR -T7651 ALUMINUM PLATE
PER AMS 4050 (-T7451) OR AMS 4201 (-T7651)
REF DART SPEC M7050P
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO RAISED ABOVE SURFACE AS SHOWN, MAX 0.015 TOOL RAD
- 7) WEIGHT: N/A
- 8) COSMETIC WELD REPAIR ALLOWED IF CAST FROM F357.0,
REPAIR PER AMS 2694 PRIOR TO INSPECTION AND HEAT TREAT.
NO COSMETIC WELD REPAIR ALLOWED IF MACHINED FROM 7050 PLATE
- 9) MANDATORY INSPECTION IF CAST FROM F357.0:
EACH PART MUST PASS X-RAY CL. 1 GR. B PER AMS 2175
EACH PART MUST PASS FPI CL. 1 GR. B PER AMS 2175
NO X-RAY OR FPI REQUIRED IF MACHINED FROM 7050 PLATE
- 10) ALL NON DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.030 PER
CAD FILE D5415-1-REV. D.STP
- 11) ANY ADDITIONAL MATERIAL REQUIRED FOR POST-CASTING MACHINING IS
NOT SPECIFIED ON THIS DRAWING.

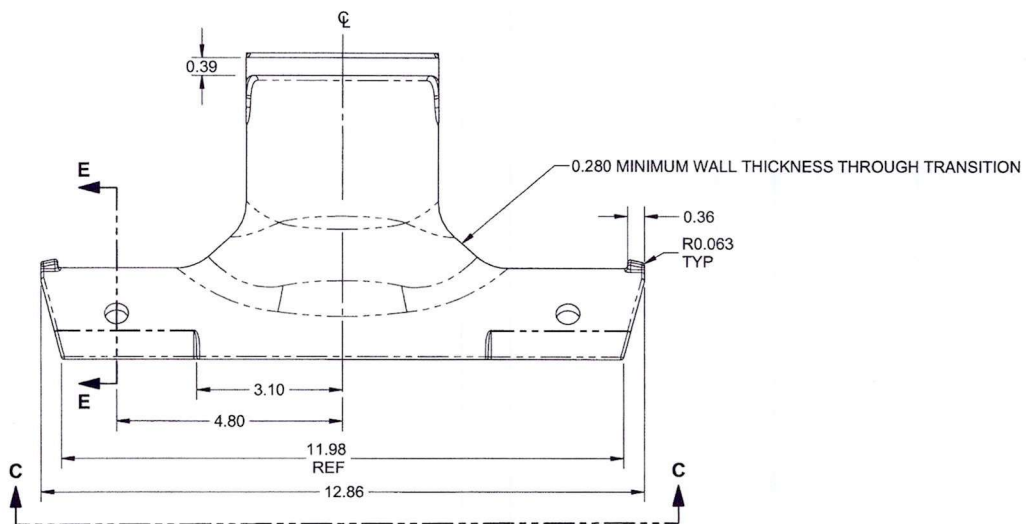
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2019 FEB 15

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DRAWN	ZF		
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MFG. APPR.	RQ	D5415	SHEET 2 OF 4
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DE APPR.	CP	SADDLE	NTS
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D5415-3C STANDARD HEIGHT SADDLE

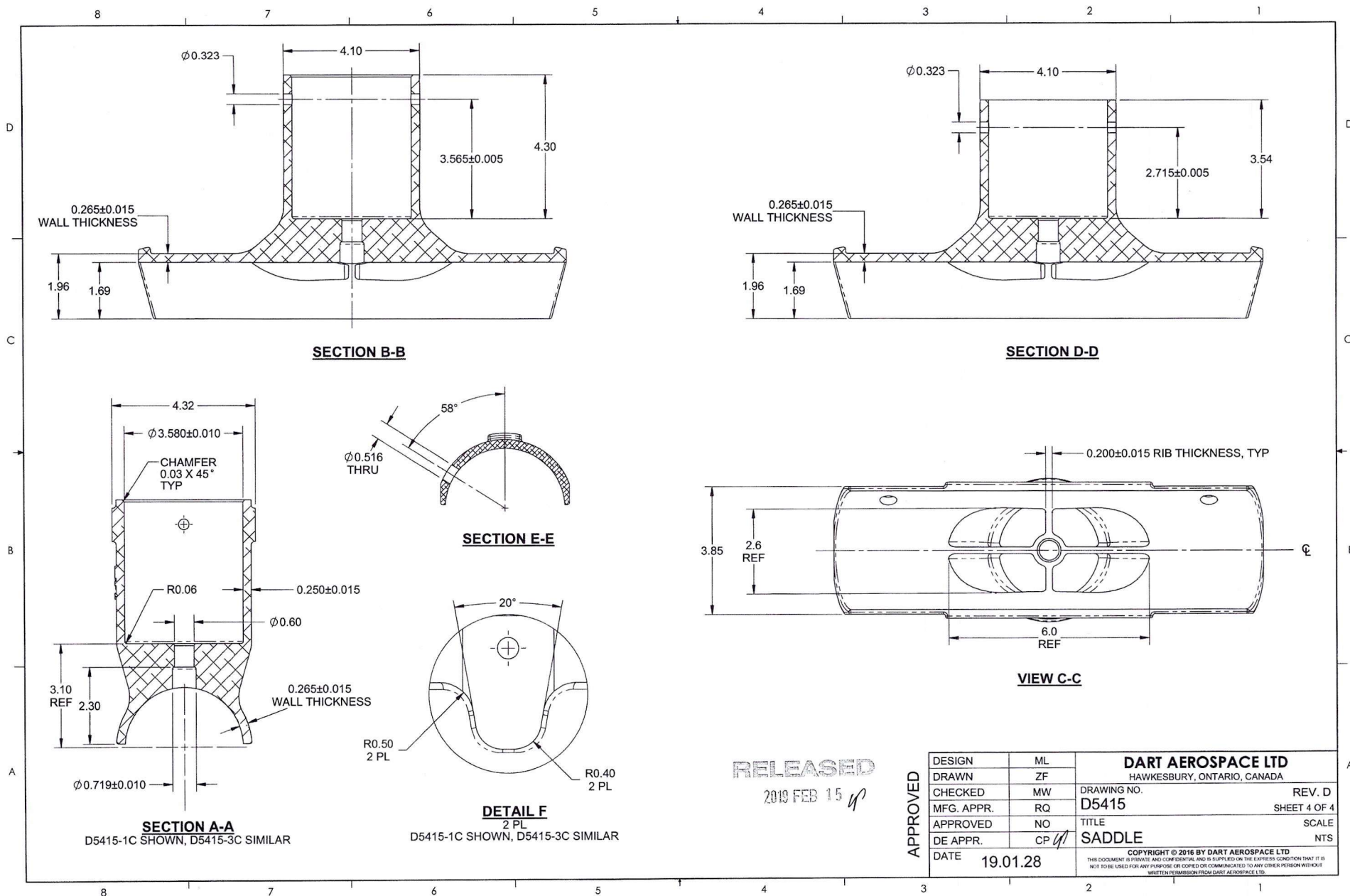


- NOTES:**
- 1) MATERIAL: CAST FROM F357.0 PER AMS 4289 AND HEAT TREAT TO T6 CONDITION PROPERTIES TO BE VERIFIED BY SUB-SIZED SEPARATELY CAST TEST BARS OR
 △ MACHINE FROM 7050-T7451 OR -T7651 ALUMINUM PLATE PER AMS 4050 (-T7451) OR AMS 4201 (-T7651) REF DART SPEC M7050P
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART LOGO RAISED ABOVE SURFACE AS SHOWN, MAX 0.025 TOOL RAD
 - 7) WEIGHT: N/A
 - 8) COSMETIC WELD REPAIR ALLOWED IF CAST FROM F357.0, REPAIR PER AMS 2694 PRIOR TO INSPECTION AND HEAT TREAT. NO COSMETIC WELD REPAIR ALLOWED IF MACHINED FROM 7050 PLATE
 - 9) MANDATORY INSPECTION IF CAST FROM F357.0:
 EACH PART MUST PASS X-RAY CL. 1 GR. B PER AMS 2175
 EACH PART MUST PASS FPI CL. 1 GR. B PER AMS 2175
 NO X-RAY OR FPI REQUIRED IF MACHINED FROM 7050 PLATE
 - 10) ALL NON DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.030 PER CAD FILE D5415-3-REV D.STP
 - 11) ANY ADDITIONAL MATERIAL REQUIRED FOR POST-CASTING MACHINING IS NOT SPECIFIED ON THIS DRAWING.

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2019 FEB 15

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CHECKED	MW	DRAWING NO. D5415	REV. D
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APPROVED	NO	TITLE SADDLE	SCALE NTS
DE APPR.	CP		
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2010 FEB 15

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